

Work Order ID 163490

Tuesday, June 27, 2017 1:22:55 PM

163490

Page 1

Item ID: D4462-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Baffle
 Start Date: 6/27/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/3/2017 Req'd Qty: 2.00 ***2*** Customer:

Reference: DAS
 Approvals: Process Plan: 21 Date: JUN 28 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4462	E								
100		0.02							
100									
Waterjet	Memo	0.42							
FLOW CNC Waterjet	Cut as per dwg								
	Prog rev: <u>E</u>								
	Dwg rev: <u>E</u>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.02							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.04							
Quality Control									

DAS
38
9-89
JUL 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC	Bend as per dwg	0.16			DAS 30 9-89	(2)			JUL 01 2017
Brake NC	Memo FLANGE HOLES AS PER DWG	0.43							
	Form as per dwg****,ensure that tabs are bent the right direction****								
140 *140* QC	QC6- All purchased or subcontracted products	0.00				2			DAS 38 9-89 JUL 04 2017
Quality Control	Memo	0.00							
150 *150* HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				(x2)	Ø		2017/07/04 BEB
Hand Finishing	Memo	0.80							

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
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Picklist Print

Tuesday, June 27, 2017 1:22:58 PM

Page 1

Work Order ID: 163490

163490

Parent Item: D4462-1

D4462-1

Parent Item Name: Baffle

Start Date: 6/27/2017

Required Date: 7/3/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC IPP REV:B
13.10.28 DWG REV PD1 DD VERF:JLM IPP REV:C 14.06.13
AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	324.7860	2.2	4.631579			
M6061T6S 063									**	7.6		06/17/07/02	
6061-T6 .063 Sheet													

Location

Loc Qty

Loc Code

MAT021

324.786

M134604

49.01

M134830

2.456

M136251

26.2

M136790

9.9

M136896

2.2

M137041

2.52

M137175

27.3

M137513

144.8

M137599

60.4

3.8

3.8

DQA: _____ Date: _____

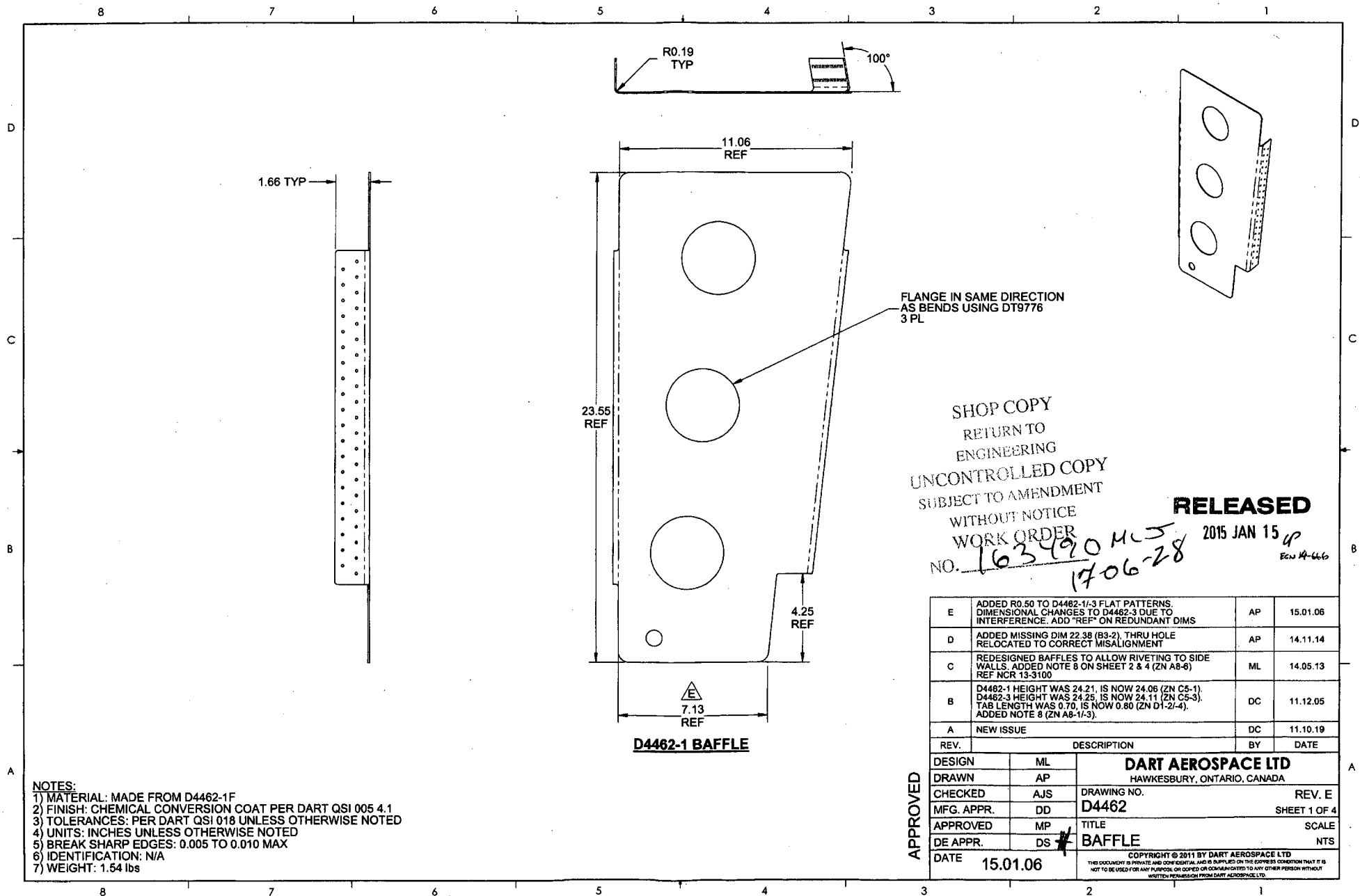


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NOTES:

- 1) MATERIAL: MADE FROM D4462-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.54 lbs

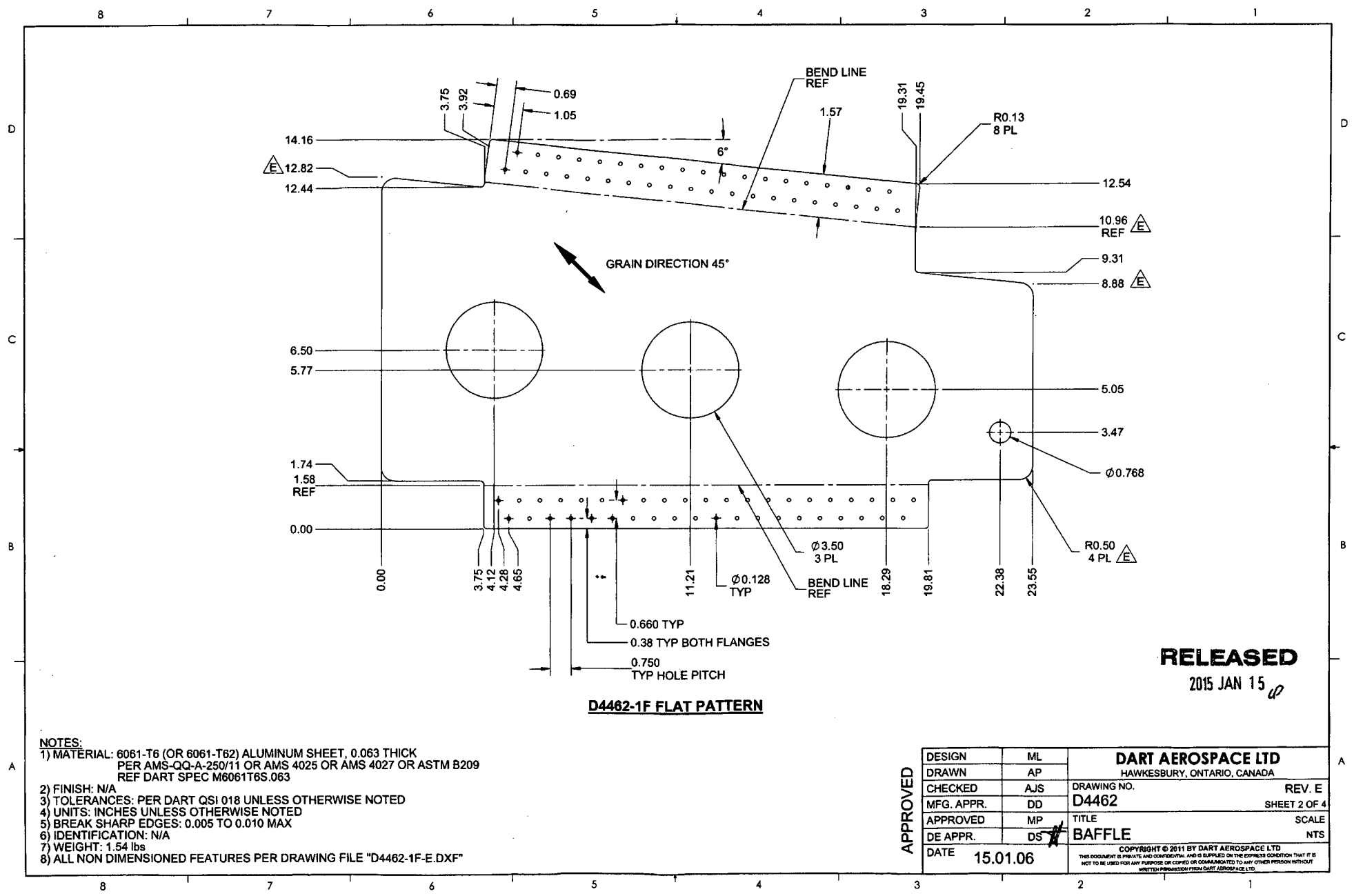
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163490 MJS
1706-28

RELEASED

2015 JAN 15

ECN 14-666

E	ADDED R0.50 TO D4462-1/3 FLAT PATTERNS. DIMENSIONAL CHANGES TO D4462-3 DUE TO INTERFERENCE. ADD "REF" ON REDUNDANT DIMS	AP	15.01.06
D	ADDED MISSING DIM 22.38 (B3-2) THRU HOLE RELOCATED TO CORRECT MISALIGNMENT	AP	14.11.14
C	REDESIGNED BAFFLES TO ALLOW RIVETING TO SIDE WALLS. ADDED NOTE 8 ON SHEET 2 & 4 (ZN A8-6) REF NCR 13-3100	ML	14.05.13
B	D4462-1 HEIGHT WAS 24.21, IS NOW 24.06 (ZN C5-1). D4462-3 HEIGHT WAS 24.25, IS NOW 24.11 (ZN C5-3). TAB LENGTH WAS 0.70, IS NOW 0.80 (ZN D1-2/-4). ADDED NOTE 8 (ZN A8-1/-3).	DC	11.12.05
A	NEW ISSUE	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	DD	D4462	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	BAFFLE	NTS
DATE	15.01.06	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4462-1F FLAT PATTERN

RELEASED
2015 JAN 15

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.54 lbs
 - 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILE "D4462-1F-E.DXF"

APPROVED	DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. E
	MFG. APPR.	DD	D4462	SHEET 2 OF 4
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	BAFFLE	NTS
DATE		15.01.06	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	